

Work Order ID 151087

Monday, September 12, 2016 10:30:31 AM

151087

Page 1

Item ID: D4271-027

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Fitting Assembly Aft Beam

Start Date: 9/8/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: SEP 14 2016 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	D ✓								
100		0.00							
100									
Small Fab									
Small Fab	Memo	0.20							
	Assemble as per dwg D4271								
	REAM HOLE AS PER DWG								
	CUT RIVET AT 1.130"								
	C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC									
Quality Control	Memo	0.01							
120	Identify as per dwg & Stock Location: <u>ST374</u>	0.00							
120									
Packaging									
Packaging	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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151087

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N900040100

Setup Start *NS1*

Stop *NS2*

?

Cust Item ID:

Start Date: 9/8/2016 **Start Qty:** 2.00

Required Date: 9/12/2016 **Req'd Qty:** 2.00

?

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.03

Quality Control

DAS
21
9-89

NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 151087

151087

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3 *D4148-3* Stud Receiver, Lower		Manufactured	No			100	Each	19.0000	1	2		NOV 07 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				9					
				146091				9					
				ST090A				10					
				148216				10					
D4148-5 *D4148-5* Eyebolt Stud		Manufactured	No			100	Each	13.0000	1	2		NOV 07 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				13					
				143355				1					
				146926				12					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	15.0000	1	2		NOV 07 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				15					
				145996				15					
D4419-3 *D4419-3* Aft Support Plate		Manufactured	No			100	Each	11.0000	2	4		NOV 07 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				11					
				145710				8					
				146829				3					

DQA: _____ Date: _____

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Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

AN4C13A Purchased No
AN4C13A
BOLT

100 Each 110.0000 2 4

**** 135966**

NOV 07 2016 **DAS 6 9-89**

Location	Loc Qty	Loc Code
GA	6	
m134754	6	
OVER002	60	
m135135	30	
m135390	30	
ST344	44	
m134508	44	

MS20427M4-20 Purchased No
MS20427M4-20
RIVET

100 Each 90.0000 1 2

~~NOV 07 2016~~ **DAS 36 9-89** 16/11/23

Location	Loc Qty	Loc Code
GA	90	
118429	90	

MS20615-4M18 Purchased No
MS20615-4M18
Rivet

100 Each 180.0000 10 20

**** 135704x1**

NOV 07 2016 **DAS 6 9-89**

Location	Loc Qty	Loc Code
GA	40	
m134762	40	
OVER007	100	
m135127	50	
<u>m135297</u>	50	
ST306	40	
m134955	40	

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Shop Packet Print

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151087

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

1,183.000

2

4

MS21043-4

NOV 07 2016

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

800

m135530

300

m135600

500

ST302

326

m135390

26

m135407

300

NAS1149C0432R

Purchased

No

100

Each

1,711.000

4

8

NAS1149C0432R

NOV 07 2016

WASHER

Location

Loc Qty

Loc Code

GA

800

m125807

427

m134676

373

ST266

911

m135544

911

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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